

Ship Jan 20th

Work Order ID 155098

155098

Page 1

Monday, January 09, 2017 7:23:15 AM

Item ID: 647.7501 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lower Cutter Assembly
 Start Date: 1/10/2017 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/20/2017 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: VS Date: 1/11/09 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
647.7500	A

110 Pick Kit 0.00

110

Packaging Memo 0.00
 Packaging

DAS
6
9-89

JAN 25 2017

120 0.00

120

Small Fab Memo 0.00
 Small Fab

Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.

A/R RTV LOCTITE 598: 1135385
 exp. date: 04/18

IX

DAS
36
9-89
17/02/17

130 QC5- Inspect part completeness to step on W/O 0.00

130

QC Memo 0.00
 Quality Control

DAS
38
9-89

FEB 02 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>CC5001</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.02							
Quality Control									

DAS
21
9-89

FEB 03 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Monday, January 09, 2017 7:23:21 AM

Page 1

155098

647 7501

Start Date: 1/10/2017**Required Date:** 1/20/2017**Start Qty: 1.00**

Required Qty: 1.00

Comments: IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.7813		Manufactured	No				Each	0.0000		1			
647 7813									**				
Center Plate, Lower													
647.7810		Manufactured	No				Each	1.0000		1			
647 7810									**				
Bracket A													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				CCK077A			1						
							1						
647.7811		Manufactured	No				Each	1.0000		1			
647 7811									**				
Bracket B													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				CCK077A			1						
							1						
646.3015		Manufactured	No				Each	0.0000		2			
646 3015									**				
Blade													
647.7601		Manufactured	No				Each	2.0000		1			
647 7601									**				
Lower Deflector Assembly													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				cck065			2						
							2						

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 155098

155098

Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 1/10/2017

Required Date: 1/20/2017

Start Qty: 1.00

Required Qty: 1.00

647.7815 Manufactured No

Each 6.0000 1

647 7815

Fwd Bracket

DAS
6
9-89

JAN 25 2017

Location

Loc Qty

Loc Code

CCK114

6

153331

6

Each

6.0000

1

647.7814

Manufactured No

647 7814

Fwd Bracket

DAS
6
9-89

JAN 25 2017

Location

Loc Qty

Loc Code

CCK114

6

153332

6

Each

7.0000

1

647.7816

Manufactured No

647 7816

Aft Bracket

DAS
6
9-89

JAN 25 2017

Location

Loc Qty

Loc Code

CCK114

7

153618

7

Each

5.0000

1

647.7817

Manufactured No

647 7817

Aft Bracket

DAS
6
9-89

JAN 25 2017

Location

Loc Qty

Loc Code

CCK115

5

153334

5

DQA: _____ Date: _____



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Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 1/10/2017

Required Date: 1/20/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149FN832P

Purchased

No

Each

1,551.000

26

NAS1149FN832P

Washer

DAS
6
9-89

JAN 25 2017

Location

Loc Qty

Loc Code

GA

232

M135058

232

ST263

1319

M136182

1319

Each

0.0000

3

MS21042-3

MS21042L3

Purchased

No

MS21042-3

Nut

DAS
6
9-89
JAN 25 2017

MS21042-08

MS21042L08

Purchased

No

Each

0.0000

13

MS21042-08

USE MS21042L08

DAS
6
9-89
JAN 25 2017

NAS1149F0332P

Purchased

No

Each

2,746.000

6

NAS1149F0332P

Washer

DAS
6
9-89
JAN 25 2017

Location

Loc Qty

Loc Code

GA

343

m133709

343

ST260a

1800

m136442

1800

ST262

603

m135948

603

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Monday, January 09, 2017 7:23:21 AM

Page 4

Work Order ID: 155098

155098

Parent Item: 647.7501

647 7501

Parent Item Name: Lower Cutter Assembly

Start Date: 1/10/2017

Required Date: 1/20/2017

Start Qty: 1.00

Required Qty: 1.00

MS27039-08-19

Purchased

No

Each

221.0000

7

MS27039-08-19

Screw

DAS
6
9-89

JAN 25 2017

Location

Loc Qty

Loc Code

GA

164

m135948

164

ST277

57

m136199

15

m136301

42

MS27039-1-19

Purchased

No

Each

186.0000

3

MS27039-1-19

Screw

DAS
6
9-89

JAN 25 2017

Location

Loc Qty

Loc Code

GA

80

m134134

80

ST280

106

m136182

106

MS27039-08-24

Purchased

No

Each

227.0000

6

MS27039-08-24

Screw (MS27039-0824)

DAS
6
9-89

JAN 25 2017

Location

Loc Qty

Loc Code

GA

227

124326

227

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

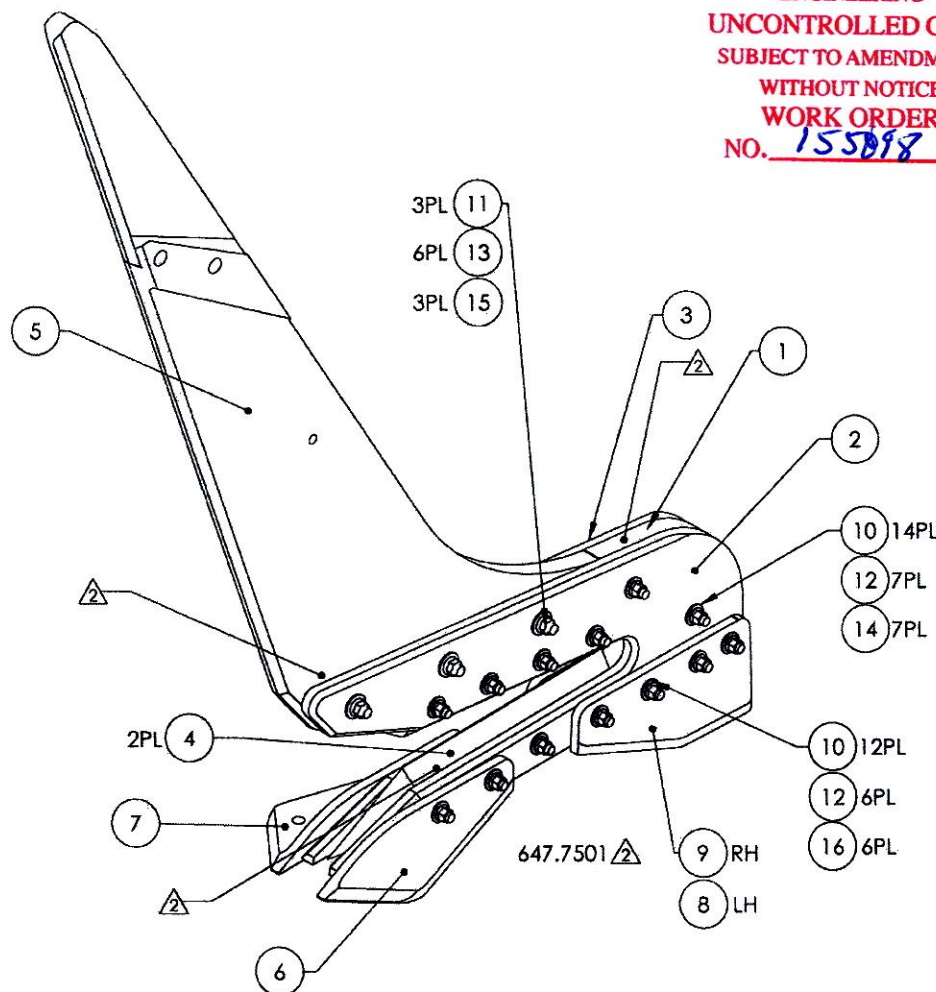
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

NOTES:

1. IDENTIFY IAW MPP-120
2. APPLY F/N 17 AS REQUIRED TO ALL FAYING SURFACES UPON ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 155898

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION P92		N/C
N/C	INITIAL RELEASE	12-27-07	P BRAVO
A	INCORPORATED ECH 02940	07-16-10	P BRAVO



A/R		601.2045	RTV. LOCTITE 598		
6	16	601.3124	SCREW	MS27039-0824	
3	15	601.1948	SCREW	MS27039-1-19	
7	14	601.2765	SCREW	MS27039-0819	
6	13	601.1607	WASHER	NAS1149F0332P	
13	12	601.2973	LOCKNUT	MS21042-08	
3	11	601.2943	LOCKNUT	MS21042-3	
26	10	601.2764	WASHER	NAS1149FN832P	
1	9	647.7817	AFT BRACKET		
1	8	647.7816	AFT BRACKET		
1	7	647.7814	FORWARD BRACKET		
1	6	647.7815	FORWARD BRACKET		
1	5	647.7601	LOWER DEFLECTOR ASSY		
2	4	646.3015	BLADE		
1	3	647.7811	BRACKET B		
1	2	647.7810	BRACKET A		
1	1	647.7813	CENTER PLATE LOWER		
		647.7501	LOWER CUTTER ASSY		
7501	FIND #	PART #	DESCRIPTION	MAT'L	SPEC

QTY	ORIGINAL DATE INQ-DA-778 11-24-89	PARTS LIST	
NEXT ASSY (\$)	C-DECEMBER A. QUAN. P. BRAYO	APICAL INDUSTRIES	
647.7300	DRAWING APPROVAL 12-21-89 CONTRACT NO.	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-53	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACES DECIMALS .010 2 PLACES DECIMALS .010 ANGLES .5°		LOWER CUTTER ASSY	
		REV. CASE CODE	DWG. NO.
		8 07M46	647.7500
		SCALE: NONE	SHEET 1 OF 2

DQA: _____ Date: _____



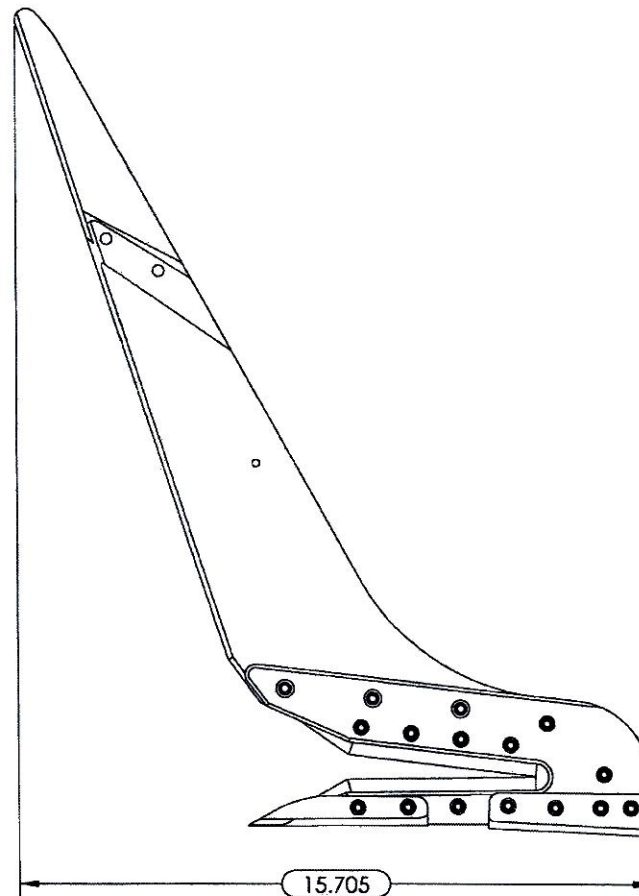
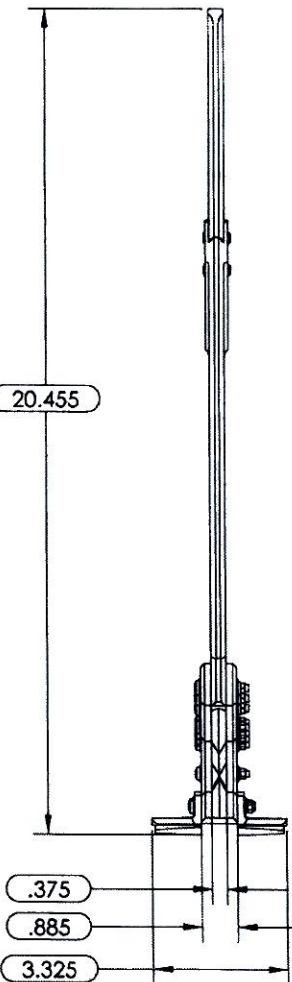
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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ORIGINAL DATE 11-24-09		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY A. GIAN	CHECKED P. BRAVO		
DRAWING APPROVAL P. BRAVO	11-24-09		
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±0.005 ANGLES ± 5°		REV. A	REV. A
SCALE NONE	SHEET 2 OF 2		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
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				Lead hand / Supervisor Approval Verification	
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					